

36

DART AEROSPACE LTD	Work Order:	19472
Description: Bearpaw Kit (13" x 16")	Part Number:	K10005
Dwg: D2671 Rev. B1	Qty:	3 Kits
Ref: K10005 Rev. A		Page 1 of 1

Step	Location	Procedure	By	Date	Qty																																																
1	DC	Issue Traveler Note: (1) K10005 Kit consists of Qty (2) D2671 Dwg not required	HJ	03.08.05	3																																																
2	DC	Photocopy bluefile: K10005 D206-559-021 D500-572-021 and create labels per PPP K10005 CHG002 (Bag Bluefiles separately)	FOL KS WK 34 HJ	SAC	03.08.13																																																
3	GA	Cut 2 blanks per (1) K10005 Kit Cut blank: 13.00" x 16.00" x 1.00" thick Material: Black UHMW 1" (MUHMWB10)	Batch: M13578	SL	03.08.07 B																																																
4	MV	Inspect material for defects or damage prior to machining	SP	03.08.07	3																																																
5	MV	Machine as per Folio and Dwg D2671	SP	03.08.07	3																																																
6	QC2	Inspect parts as they come off the CNC machine	SP	03.08.08	3																																																
7	MV	Deburr	SP	03.08.08	3																																																
8	QC8 & 5	Second inspection	UC	03.08.08	3																																																
9	KP	Pick: Packing Kit (Note: D2671 is on the BOM as material from step 3) <table border="1"> <tr> <th>Qty</th> <th>Part Number</th> <th>Description</th> <th>Batch</th> </tr> <tr> <td>4</td> <td>D2182B050</td> <td>Rubber Cushion</td> <td>B18914</td> </tr> <tr> <td>8</td> <td>D2274</td> <td>Radius Block</td> <td>B19107-B18911</td> </tr> <tr> <td>2</td> <td>D2671</td> <td>Bearpaw</td> <td>B19472</td> </tr> <tr> <td>4</td> <td>D2438</td> <td>Clamp</td> <td>B18905</td> </tr> <tr> <td>8</td> <td>D2529</td> <td>Washer</td> <td>B18539</td> </tr> <tr> <td>8</td> <td>AN4-15A</td> <td>Bolt</td> <td>M13437</td> </tr> <tr> <td>8</td> <td>AN4-17A</td> <td>Bolt</td> <td>M17413</td> </tr> <tr> <td>16</td> <td>AN960JD416</td> <td>Washer</td> <td>M12149</td> </tr> <tr> <td>8</td> <td>MS21042L4</td> <td>Nut (or -4)</td> <td>M12000</td> </tr> <tr> <td>2</td> <td>QS200M44S</td> <td>Clamp</td> <td>M13530</td> </tr> <tr> <td>1</td> <td>Paperwork package from Step 2</td> <td></td> <td></td> </tr> </table>	Qty	Part Number	Description	Batch	4	D2182B050	Rubber Cushion	B18914	8	D2274	Radius Block	B19107-B18911	2	D2671	Bearpaw	B19472	4	D2438	Clamp	B18905	8	D2529	Washer	B18539	8	AN4-15A	Bolt	M13437	8	AN4-17A	Bolt	M17413	16	AN960JD416	Washer	M12149	8	MS21042L4	Nut (or -4)	M12000	2	QS200M44S	Clamp	M13530	1	Paperwork package from Step 2			Q	B00-13	3.
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10	QC4	Inspect Kit for 100% Completeness on the W/O	LL	03.08.13	3																																																
11	PK	Identify and pack for shipping as per PPP K10005	REV. C	Q	03.08.26 3.																																																
12	AC	Cost / part <u>142.93</u>	SAC	03.08.27	3																																																
13	DC	Close W/O <u>192.93</u> Inspect Level 21	AA	03.08.27	-																																																

Rev	Date	Change	Revised By	Approved
A	99.12.17	K10005 created for Bearpaw Kit	EC	
B	03.05.28	Reformat; Incorporated D2671	KJ/RF	TH TH

BB. 03-08-27 RB

RELEASED
03.06.10 RF

Work Order:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Manuf/ Design Mgr	Approval QC Inspector

NCR		WORK ORDER NON-CONFORMANCE							
DATE	STEP	Description of NC section A	Corrective Action Section B			Sign & Date	Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial						

PAR#: _____ Fault Category: _____ DQA: _____ Date: _____

NOTE: Date & initial all entries
H:\Admin-QA\ISO\forms\w\oncB.doc

QA: N/C Closed: _____ Date: _____

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Aug 05, 2003
01:13 pm

Work Order No : 0019472
 Project Name : *K10005
 Project For : WK336
 Work Order Type : Main
 Main WO Number :
 House Part Number : *K10005
 Description : Bearpaw kit 13" x 16"
 Manufactured : Yes
 Amount Req'd : 3
 Amount Done : 0
 Start Date : 08-05-03
 Est Finish Date : 08-31-03
 Act Finish Date :
 Drawings Reqd : No
 Ok for Approval :
 Approval Rec'd : \$0 Posted to Finished Goods

Department Code:
 Burden Flags : NNNNNNN
 WO Status : Open
 Invoice State : Not Invoiced
 Invoice Date :
 Invoice Number :
 Invoice Amount : 0.00

Order Entry No :
 OE Value : 0.00

Est Margin : 0.000%
 Actual Margin : 0.000%

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00	0.00	0.00
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00	0.00	0.00
Production Cost :	0.00	0.00	0.00	0.00	0.00
Testing Hours :	0.00	0.00	0.00	0.00	0.00
Testing Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00	0.00	0.00
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
SubContract Hours :	0.00	0.00	0.00	0.00	0.00
SubContract :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00	0.00	0.00
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00	0.00	0.00
Total Cost :	0.00	0.00	0.00	0.00	0.00
Margin :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss)	0.00	0.00



Dart Aerospace, Ltd
1270 Aberdeen Street
Hawksbury, Ontario
K6A 1K7
Tel: (613) 632-3336 Fax: (613) 632-4443

Supplier Code: _____ Sheet ___ of ____

INSPECTION CHECKLIST

PART NO.: A2671

PHY. CHANGE: _____

DESCRIPTION: Bumper

DRAWING CHANGE: REV.B

MANUFACTURING DATE: 03/08/07

UNICORP E.O.'S: _____

BATCH NO.: 19472

SERIAL NO.: _____

PURCHASE ORDER NO.: _____

QUANTITY ACCPT. _____ REJ. _____

DATA SHEET NO.: _____

FIRST ARTICLE PERIODIC CONFORMITY FINAL INSPECTION

ITEM	DWG PAGE	DRAWING DIMENSION	TOL.	ACTUAL DIMENSION	ACC.	REJ.	% OF INSP.	Method of Inspection	Comments
1	1	10.32 ± .00	"	10.30	✓		100%	EMI	
1	1	5.500 ± .00	"	5.509	✓		"		
1	1	2.000 ± .00	"	1.95	✓		DMC		
1	1	2.000 ± .00	"	1.95	✓		DMC		
1	1	2.500 ± .00	"	2.500	✓		100%	EMI	
1	1	2.500 ± .00	"	2.500	✓		100%	EMI	
1	1	2.500 ± .00	"	2.556	✓		100%	EMI	
1	1	.620 ± .00	"	.622	✓		100%	EMI	
1	1	3.75 ± .00	"	3.73	✓		100%	EMI	
1	1	3.211 ± .00	"	3.211	✓		100%	EMI	
1	1	12.750 ± .00	"	12.750	✓		100%	EMI	
1	1	1.950 ± .00	"	1.950	✓		100%	EMI	
1	1	3.75 ± .00	"	3.84	✓		100%	EMI	
1	1	5.000 ± .00	"	5.000	✓		100%	EMI	
1	1	11.000 ± .00	"	10.993	✓		100%	EMI	
1	1	1.000 ± .00	"	1.006	✓		100%	EMI	
1	1	12.150 ± .00	"	12.150	✓		100%	EMI	
1	1	15.500 ± .00	"	15.500	✓		100%	EMI	
1	1	12.600 ± .00	"	12.600	✓		100%	EMI	
1	1	.93 ± .00	"	.935	✓		100%	EMI	
1	1	1.300 ± .00	"	1.300	✓		100%	EMI	
1	1	4.500 ± .00	"	4.500	✓		100%	EMI	
1	1	4.720 ± .00	"	4.720	✓		100%	EMI	
1	1	4.720 ± .00	"	4.720	✓		100%	EMI	
1	1	10.300 ± .00	"	10.300	✓		100%	EMI	
1	1	9.150 ± .00	"	9.150	✓		100%	EMI	
1	1	9.387 ± .00	"	9.387	✓		100%	EMI	

H:\admin-q\iso\forms\first article inspectionA

Rev. B

Measured by: SP

Audited by: EJ

Approved by: MJA